Work Order	r ID 106138		*1(1613	88*						Page 1
Revision ID: Item Name: Start Date: 8	O3065-5 Step Leg B/28/13 Start Qty: 40.0				J900		100)*	Setup Sta	1 7	S1* S2*
Required Date: 8 Reference:	Req'd Qty: 40.0	⁰⁰ *40*	•		Customer:						
Approvals:	Process Plan:M					ate:			Run Sta Sto		R1* R2*
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hou	rs	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp.
Draw Nbr	Revision Nbr	1						· ·			
D3065	Rev B										
*100 *100* Waterjet FLOW CNC Waterjet	FLOW WATER JET Memo 1-Cut as if necess	s per Dwg D Dwg Rev:	0.00 0.00 Prog Rev:	<u>B</u> 2-Debur	•			41	0		<u>1m13-10-23</u>
*110 *1110* QC Quality Control	QC2- Inspect parts o	ff machine FAI/FAIB	0.00					41			<i>Im1310-2</i> 3
120	QC8- Inspect parts -	second check	0.00	ins T				4/			
120 QC Quality Control	Memo			10 23				Con		_	·

											DQA:	Date:	
NCR: Y	es /	No				WORK ORDER NON-C	O	NFORM	AANCE / UPDA		QA Closed:	Date:	
·													·
Work Orde	er:					DISPOSITION				AGAINST DE	PARTMENT/	PROCESS	
						Rework	1		Skid-tube	Crosstube		Water Jet	Engineering
Part N	No.					Scrap		B	Machining	Small Fab	Proc	l. Eng. Coor.	Quality
				·		Use-as-is	1	Therm	noforming	Finishing	Rec/Stor	e/Packaging	Other
NCR I	No					Work Order Update			Large Fab (Composite		Supplier	
								<u> </u>					
Root		·				ption of work order update	ł	Initial	Action	1	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Cr	nief Eng	Descript	tion	Date	Verification	QC Inspector
Doc/Data	Ш		•										
Equip/Tooling													
Operator	Ш												
Material	Ш												
Setup	Ш												
Other	Щ						1						
Process													
Supplier				ļ									
Training	Ш												
Unapproved	Ш.				<u> </u>				L				<u> </u>
							AUI	LT CATE	<u>SORY</u>				
Landi	ng Ge				F	General		٦		F	l	_	7
	Н	ending			.	Bend	-	Grain			Ovalized		Pressure/Forced
	\vdash		t Conce	ntric to	o/s	BOM/Route	\vdash	Hardwa			Over/Under	 	Temperature/Cure
	\vdash	racks			<u> </u>	Broken/Damaged	\vdash	-i '	ion Incomplete		Part Incorred	<u> </u>	Weld
	⊢		Crimped		<u> </u>	Burrs	<u></u>	Instructions Incomplete/Unclear			Part Lost/Missing		Wrong Stock Pulled
		uffs			<u> </u>	Contamination	L	Mainte			Part Moved		
Į.	l lH	eat Trea	t			Countersink	1	Mislabeled			Positioned W	/rong	

Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Other

Power Loss/Surge

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish

Folio

0.00

Memo

Packaging

Packaging



												DQA:	Da	ite:	
NCR:	'es	/ No				WORK ORDER NON-	CON	NFORM	AANCE / UP	DATE					
												QA Closed:	Da	ite:	
Work Orde						DISPOSITION				AGAINST [ÞΕ	PARTMENT,	PROCESS		
WORK Of UK	-					Rework	ן ר		Skid-tube	Crosstube			Water Jet		Engineering
Part N	JO.					Scrap	1		Machining	Small Fab	-	Pro	d. Eng. Coor.	-	Quality
	•					Use-as-is	1		noforming	Finishing			re/Packaging	_	Other
NCR I	No.					Work Order Update	1 1		Large Fab	Composite			Supplier		
												·			
Root					1	ption of work order update		Initial		ction		Sign &			
Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Desc	ription		Date	Verification	n	QC Inspector
Doc/Data	Ш					•									}
Equip/Tooling				i											
Operator															
Material	Ш							·							
Setup	Ш														
Other	Ш														
Process			1												
Supplier			Ì												
Training	_														
Unapproved			<u> </u>										<u> </u>		
						AUI	LT CATE	GORY		_					
Landi					_	General	_	۱		ſ		1]
	<u> </u>	Bending			- L	Bend	-	Grain				Ovalized	*=[====	-	Pressure/Forced
	_	Centre N	ot Conce	ntric to	^{0/S} -	BOM/Route	\vdash	Hardwa				Over/Under		\vdash	Temperature/Cure
	<u> </u>	Cracks			<u> </u>	Broken/Damaged	-	4	ion Incomplete	,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,		Part Incorre		-	Weld
	<u> </u>	Crushed/	Crimped		<u> </u>	Burrs	\vdash	4	ions Incomplete,	/Unclear		Part Lost/M	issing		Wrong Stock Pulled
	<u> </u>	Cuffs				Contamination	-	Mainte		}		Part Moved	A (
	<u></u>	Heat Trea			<u> </u>	Countersink	\vdash	Mislabe		}		Positioned V	-	_	J _{0.1}
	1	Inspectio	n Strip in	Tube	-	Cut Too Short	1	Misread	d			Power Loss/	Surge		Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

Folio

Work Ord	er ID 10	06138			*106					Page 3			
August-28-13 1	:14:14 PM				1 1 17)							
Item ID: Revision ID:	D3065-5			1	Accept	*N900	040	100)*	Setup	Start Stop		S1* S2*
Item Name: Start Date: Required Date Reference:	8/28/13 : 8/28/13	Start Qty: 40.00 Req'd Qty: 40.00		*40* *40*		Cust Item I Customer:	D:				·	"IN	5 /"
Approvals:	Process Pl QC:	an:	Date:_ Date:_		Tooling: SPC (Y/N):		nte:			Run	Start Stop	*N *N	R1* R2*
Sequence ID/ Work Center I	D	Operation Description QC21- Final Inspection -	Work Orde	r Release	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accep Qty	Qt	•	Reject Number	Insp. Stamp

0.00

Memo

160

Quality Control

13/11/21/20 12/11/20

											DQA:	Date:	
NCR: Y	Yes	/ No				WORK ORDER NON-	COI	VFOR	MANCE / UP			•	
											QA Closed:	Date:	
Work Orde	or.					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
	-					Rework]		Skid-tube	Crosstube	Dan	Water Jet	Engineering
Part N	No			_		Scrap	-		Machining	Small Fab		d. Eng. Coor. re/Packaging	Quality Other
NCR N	No.					Use-as-is Work Order Update		mem	noforming Large Fab	Finishing Composite	Nec/Stol	Supplier	Other
Root		·			Descri	ption of work order update		Initial	Act	tion	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Ch	nief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data													!
Equip/Tooling									i				
Operator													
Material	Ш												
Setup	Ш												
Other	Ш												
Process													
Supplier			1										
Training							1						
Unapproved								-					
						-	AUI	LT CATE	GORY				
Landi	ing G	Gear				General		-			•		•
		Bending				Bend		Grain			Ovalized		Pressure/Forced
		Centre N	ot Conce	ntric to	o/s \Box	BOM/Route		Hardwa	ire		Over/Under	tolerance	Temperature/Cure

Inspection Incomplete

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Instructions Incomplete/Unclear

Part Incorrect

Part Moved
Positioned Wrong

Part Lost/Missing

Power Loss/Surge

Weld

Other

Wrong Stock Pulled

Broken/Damaged

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish Folio

Burrs

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Cracks

Cuffs

Heat Treat

Crushed/Crimped

Inspection Strip in Tube

Torque Waves in Extrusion

Picklist Print

August-28-13 1:14:14 PM

Work Order ID:

106138

Parent Item:

D3065-5

Parent Item Name:

Step Leg

Start Date: 8/28/13

Required Date: 8/28/13

Page 1

Start Qty: 40.00

Required Qty: 40.00

Comments:

IPP: C02.11.01Incorporated D3066-1 IPPKJ/RF IPP Rev:D Now on Water Jet 06-04-11 JLM

IPP Rev:E Now manufactured with 6061-T6 06-05-25 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.080 6061-T6 .080 Sheet		Purchased	No			100	sf	656.0000	0.825	34.736844 35		•	Im13-10-
				Location		Loc Qty	Lo	oc Code					
				MAT021		656							
				125	5812	34							
				m1	26309	363.5							
				m1	26350	258.5			126	350			

									DQA:	Date:	
NCR: Yes	/ No				WORK ORDER NON-O	CONFOR	MANCE / UF		QA Closed:	Date:	
Work Order:		<u></u>	·		DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part No.	3		2		Rework Scrap Use-as-is	Ther	Skid-tube Machining moforming	Crosstube Small Fab Finishing	ŀ	Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR No.					Work Order Update]	Large Fab	Composite		Supplier	
Root				Descri	ption of work order update	Initial	Α	ction	Sign &		
Cause	Date	Step	Qty	(or Non-conformance	Chief Eng	Des	cription	Date	Verification	QC Inspector
Doc/Data								·			
Equip/Tooling]										
Operator	<u> </u>										
Material]										
Setup	_]				1					
Other	_]										
Process		İ									
Supplier											
Training	_										
Unapproved										<u></u>	
					F	AULT CAT	EGORY				
Landing	Gear				General						

Grain

Hardware

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Inspection Incomplete

Instructions Incomplete/Unclear

Bend

Burrs

BOM/Route

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

Broken/Damaged

Pressure/Forced

Weld

Other

Temperature/Cure

Wrong Stock Pulled

Ovalized

Part incorrect

Part Moved

Part Lost/Missing

Positioned Wrong

Power Loss/Surge

Over/Under tolerance

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Bending

Cracks

Cuffs

Heat Treat

Crushed/Crimped

Inspection Strip in Tube

Torque Waves in Extrusion

Centre Not Concentric to O/S

DART AEROSPACE LTD	Work Order:	106138
Description: Step Leg	Part Number:	D3065-5
Inspection Dwg: D3065 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
16.458	+/-0.010	16.458	_		T	Jemo6
15.750	+/-0.005	15.750"	-		T	
2.250	+/-0.005	2,253"	_		٧	Jamos
3.460	+/-0.005	3.461	-		V	
0.865	+/-0.005	0867	_		V	
6.020	+/-0.005	6.021"			V	
1.205	+/-0.005	1.209"			ν	
3.484	+/-0.005	3,486	_		V	
0.871	+/-0.005	0.874"	-		V	
8.325	+/-0.010	8.337	_		ν	Produjuz
0.551	+/-0.010	0.553'	-		V	
0.213	+0.005/-0.000	0.215"	_		ν	
Ø0.128	+0.005/-0.000	8,129"	_		V	
			DAS			

Measured by: Jm Audited by: 9-89 Prototype Approval: N/A

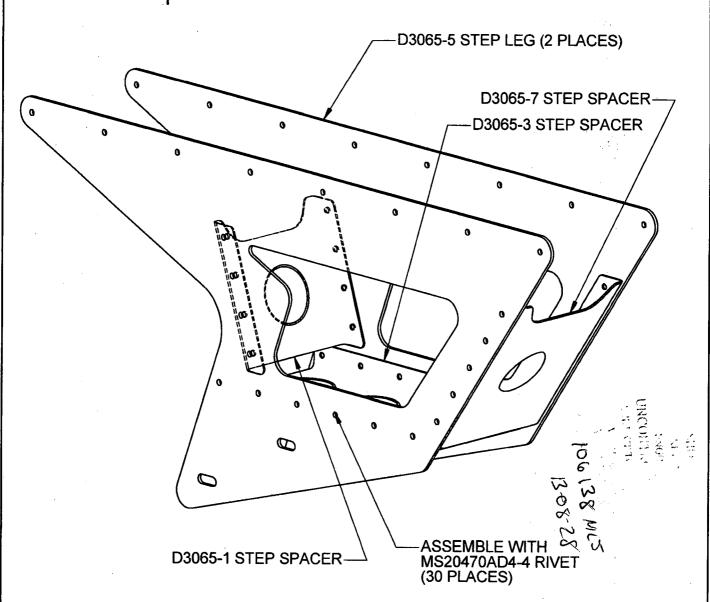
Date: 3-10-23 Date: 15 10 25 Date: N/A

Rev	Date	Change	Revised by Approved
Α	03.09.22	New Issue P/O D3065-041	KJ/RF
В	04.06.15	Added Ø0.128 dimension	KJ/JLM LA
С	06.06.23	Dwg Rev. changed	KJ/JLM A



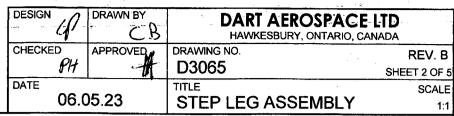
		All the second			American Section				
	DESIGN		DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA					
	CHECK	ED OU	APPROVED	DRAWING NO.	REV. B				
		PH	THE	D3065	SHEET 1 OF 5				
i	DATE	06 (05.23	TITLE STEP LEC ASSEMBLY	SCALE				
			33.23	STEP LEG ASSEMBLY	1:2				
	Α	0	2.09.11	NEW ISSUE					
	В	0	6.05.23	ADD 6061-T6 MATERIAL, ADD SLOTS	TO D3065-5				

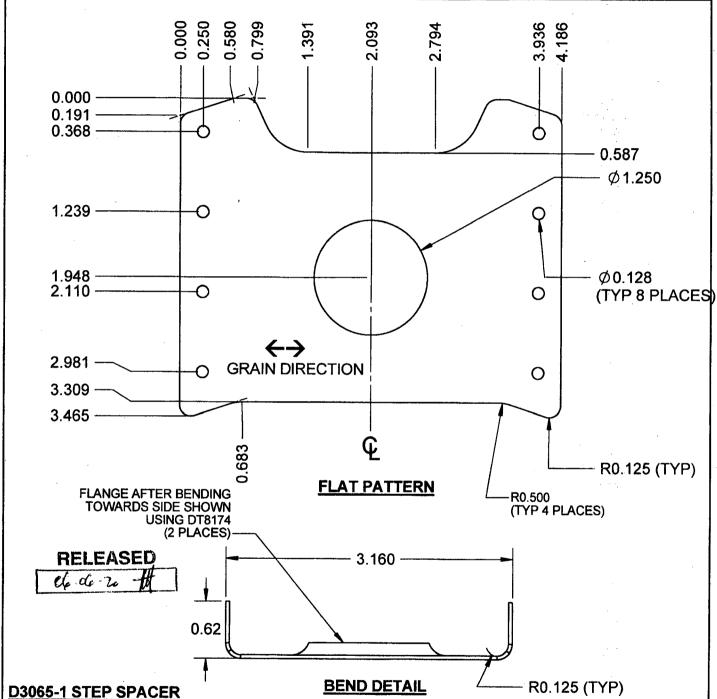
RELEASED & d 20



D3065-041 STEP LEG ASSEMBLY



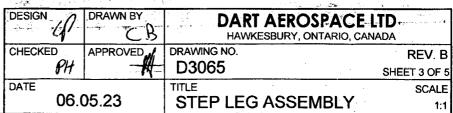


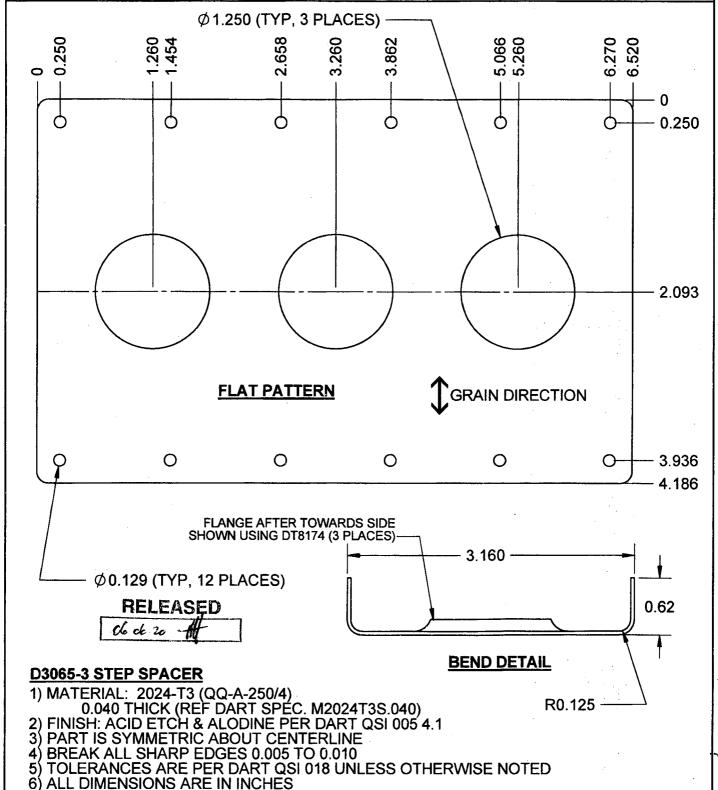


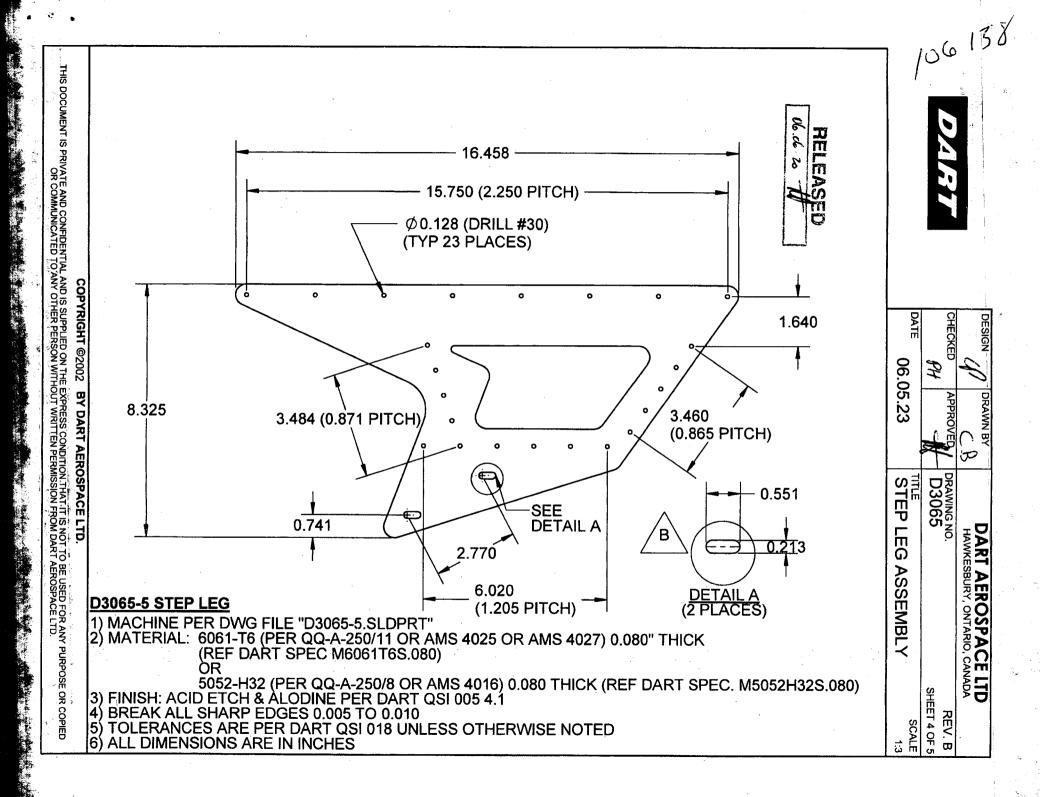
- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
 4) PART IS SYMMETRIC ABOUT CENTERLINE
 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

COPYRIGHT © 2002 BY DART AEROSPACE LTD.



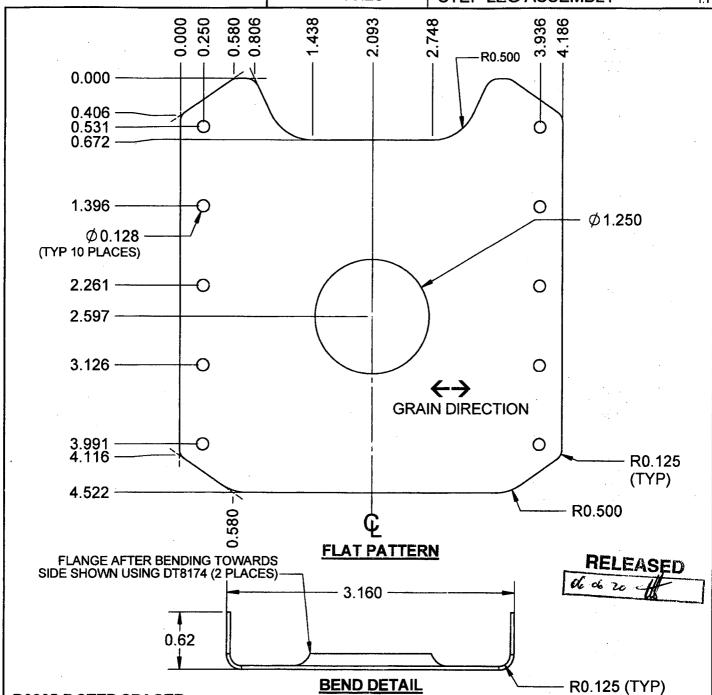












D3065-7 STEP SPACER

- 1) MATERIAL: 2024-T3 (PER QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

COPYRIGHT © 2002 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.